

Date: Tuesday, 9/4/2007 11:30:21 AM  
User: Kim Johnston

## Process Sheet

*split*  
88 07/10/10

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 34418 -2  
Estimate Number : 12315  
P.O. Number :  
This Issue : 9/4/2007 S.O. No. :  
Prsht Rev. : NC  
First Issue : 1/1 Type : SMALL /MED FAB  
Previous Run : 32049

Drawing Name : DUCT

Part Number : D34731  
Drawing Number : D3473 REV B  
Project Number : N/A  
Drawing Revision : B  
Material :  
Due Date : 10/4/2007

Qty:  $\frac{10}{6}$  Un

Written By : *[Signature]*  
Checked & Approved By : *[Signature]*  
Comment : Est Rev A New Issue 06-03-02 JLM  
Est Rev B As per Rev B 06-05-24 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description:

10 M304S26GA

304/316 0.018 SHEET



Comment: Qty.: 0.6305 sf(s)/Unit Total: 3.7832 sf(s)  
304/316 0.018 SHEET

Batch: ~~105591~~ 105591 IB 07-10-15

20 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET  
Cut as per Dwg. D3473

Dwg Rev: *B*  
Prog Rev: *B*

IB 07-10-15

30 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

40 QC8

SECOND CHECK



Comment: SECOND CHECK

50 SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Roll as per Dwg D3473

3-Form Small Flange as per Dwg D3473 using DT8861 Base &amp; Dt8847B Male Die

mf. 07-10-

mf 07-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/10/16	5	Split WO	SB	07/10/16	1			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUCT

Job Number: 34418

Part Number: D34731

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Form Large Flange as per Dwg D3473 Using DT8862

5-Spot Weld as per Dwg 3473

mf 07-10-16 (1)

mf 07-10-11

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SS 07-10-16 (1)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 07-10-16 (1)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf 07-10-16

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.16 (1)  
A

Job Completion



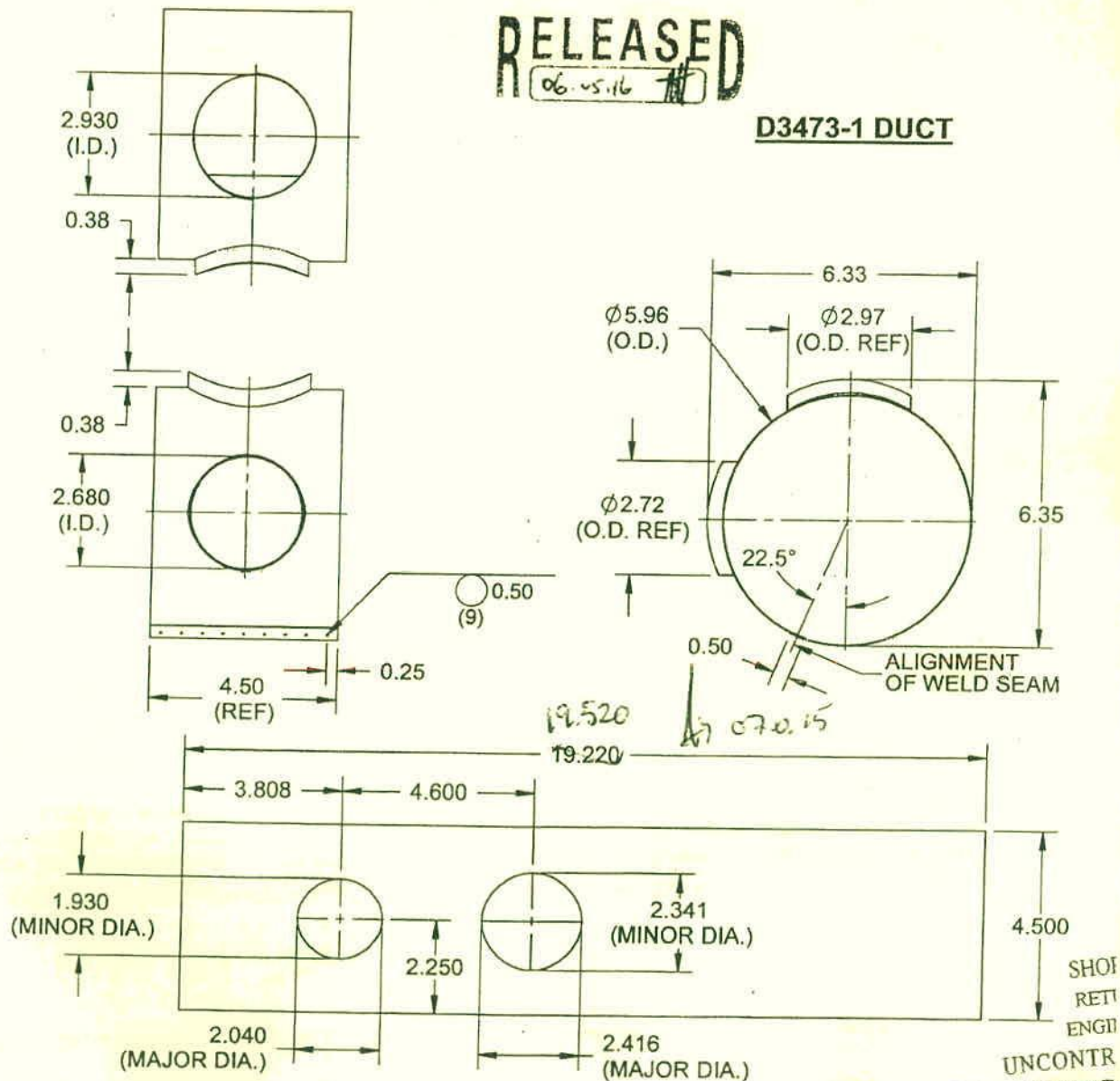
A 07.10.16





**DART**

DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD.</b> HAWKESBURY, ONTARIO, CANA
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3473</b>
DATE <b>06.05.16</b>	TITLE <b>BLOWER INLET ADAPTER</b>	

**RELEASED**  
*06-05-16***D3473-1 DUCT****D3473-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)  
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Description: Duct

Part Number:	D3473 -1
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Inspection Dwg: 03473 Rev: B

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☒ First Article      ☐ Prototype

[illegible]

Measured by:	LB
Date:	07-10-15

Audited by:	LS
Date:	07/10/15

Prototype Approval:	<i>MP</i>
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 22

EMPLOYEE: Indrani Fautey

PART NUMBER: D 3473-1

JOB NUMBER: B 34418

MATERIAL TYPE: 304L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium

## TEST RESULTS

	PASS	FAIL
VISUAL:	[ <u>/</u> ]	[ ]
PENETRATION:	[ <u>/</u> ]	[ ]
PULL STRENGTH:	[ <u>/</u> ]	[ ] PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/06/14

QUALIFIER: SB

